







Date: Thursday, 24/07/2008 8:21:26 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40607

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Soslovich*

21.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *509*

*8/9/12*

*(xa) SP*

22.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/09/15*

Job Completion



*MF 08-09-12*





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Job Number: 40607

Part Number: PB674300113

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:40  
320  
2:10

M-L 08/07/31

(5X)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/07/31

(5)

15.0

PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

90 Degree Cover Plate

batch: 340069

HE 08-08-26

16.0

PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-83

batch: 40096

HE 08-08-26

17.0

MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

batch: M108986

HE 08-08-26

18.0

NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

WASHER

batch: M108473

HE 08-08-26

19.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg

HE 08-08-26

3



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Job Number: 40607

Part Number: PB674300113

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

*Handwritten:* 08-07-28.5

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Handwritten:* 08-07-29.5

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 08/07/29

9.0 MS124780 HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

HELICAL INSERT

*Handwritten:* M 14935

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush in area of PB67-43001-249 only

2- tap drill for helicol

3- install helicol insert as per dwg

*Handwritten:* 08-07-31

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 08/07/31

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Handwritten:* 08-07-31

13.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

*Handwritten:* M 102316  
08/07/31





5811

Date: Thursday, 24/07/2008 8:21:26 AM  
User: Melanie Fauteux

Process Sheet

Duplicate

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 40607  
Estimate Number : 13436  
P.O. Number :  
This Issue : 24/07/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : 17/07/2008 Type : LARGE FAB ASSY  
Previous Run :  
Written By :  
Checked & Approved By : MF 08-07-24  
Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Drawing Name : AFT ADJUSTABLE BLADE SUPPORT ASSY  
Part Number : PB674300113  
Drawing Number : B6743001 P.8  
Project Number : N/A  
Drawing Revision : B1  
Material :  
Due Date : 24/07/2008 Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PB6743001255 Inner Tube  
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Inner Tube  
batch: 40591



08-07-22

2.0 PB6743001249 Inner Tube Bushing  
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Inner Tube Bushing  
batch: m18141



08-07-22

3.0 PB6743001253 Gusset  
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Gusset  
batch: 340711



08-07-22

4.0 PB6743001254 Gusset  
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
Gusset  
batch: 340053



08-07-22

5.0 PB674300167 PB67-43001-67  
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)  
PB67-43001-67  
batch: 340243



08-07-22